

Work Order ID 67512

Saturday, March 26, 2011 9:01:57 AM



Page 1

Item ID: D3915-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Assembly, Long Basket

Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *ME*Date: *11-03-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3915

C

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 0.00

Large Fab

1112860

Memo

0.00

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

11-03-27 (12)

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

1 0 3E 11/03/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 w/ 5/30

(40)

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ENSURE TO RINSE CAREFULLY ACID AND ALODINE

1 BR 11-8-30

140

Weld per dwg A/R Aluminum rod Batch: _____

0.00



Large Fab

Memo

0.00

Large Fab

1- weld (4) corners

M112860

11-03-31 (14)

W/O:		WORK ORDER CHANGES						
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Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

1 0 BE 11/03/31

155



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Sub 3/31

(X)

inspect fit of lid with base

157



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

1- realodine corners
do not acid etch

1 BR 11-3-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



HandFinish

Assemble as per dwg

0.00

Memo

0.00

Hand Finishing

1- Install webbing as per dwg

2- Install placard and label as per dwg

GS 4/04/01 (1)

190



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Enlo 4/04/01

(1)

200



Packaging

Identify as per dwg & Stock Location: GA

0.00

Memo

0.00

Packaging

B 67510

GS 4/04/01

(1)

W/O:		WORK ORDER CHANGES						
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

atpfl

11/4/4 [Signature]
MF
11-04-01

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Saturday, March 26, 2011 9:01:53 AM

Parent Item Name: Light Lid Assembly, Long Basket

Required Date: 4/7/2011

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1 		Manufactured	No			180	Each	0.0000	1	1		SB 11/04/01	
Dart Logo label													
D2957 		Manufactured	No			100	Each	19.0000	4	4		SY 11.03.29	
Mounting Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		19							
				63664		9							
				63750		10							
D3915-1 		Manufactured	No			100	Each	6.0000	2	2		SY 11.03.29	
Rib													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		6							
				65364		2							
				66616		4							
D4016-5 		Manufactured	No			100	Each	18.0000	3	3		SY 11.03.29	
Hinge Half, Light Lid													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		18							
				63751		4							
				66335		8							
				66541		6							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Saturday, March 26, 2011 9:01:53 AM

Page 3

Work Order ID: 67512

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00



D4056-1

Manufactured No

100

Each

7.0000

1

1



Label Plate



SP 11.03.28

Location

Loc Qty

Loc Code

WA005

7

58308

5

59750

2

(1x)

MS20600-AD4W3

Purchased

No

180

Each

1,173.000

34

34



Cherry Rivets



SP 11/04/01

Location

Loc Qty

Loc Code

ST321

517

111636

517

WA018

656

107939

656

34

NAS1149DN416J

Purchased

No

180

Each

400.0000

34

34



Washer



SP 11/04/01

Location

Loc Qty

Loc Code

ST298

400

114348

52

114597

344

13910

4

34

Saturday, March 26, 2011 9:01:53 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

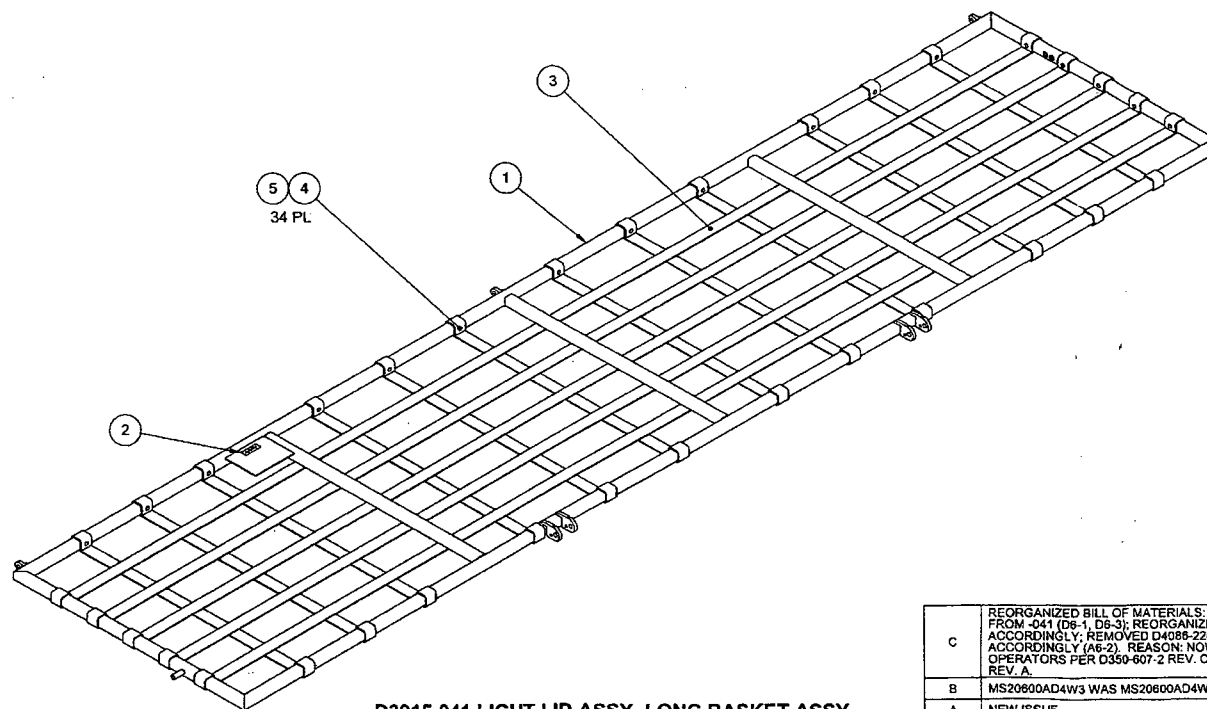
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D8-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4088-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.		MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)		JPH	10.04.06
A	NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	HLS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	S		DRAWING NO. REV. C D3915 SHEET 1 OF 4	
CHECKED	S		TITLE SCALE LIGHT LID ASSY-LONG BASKET	
MFG. APPR.	S		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED	S			
DE APPR.	S			
DATE	10.08.05			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

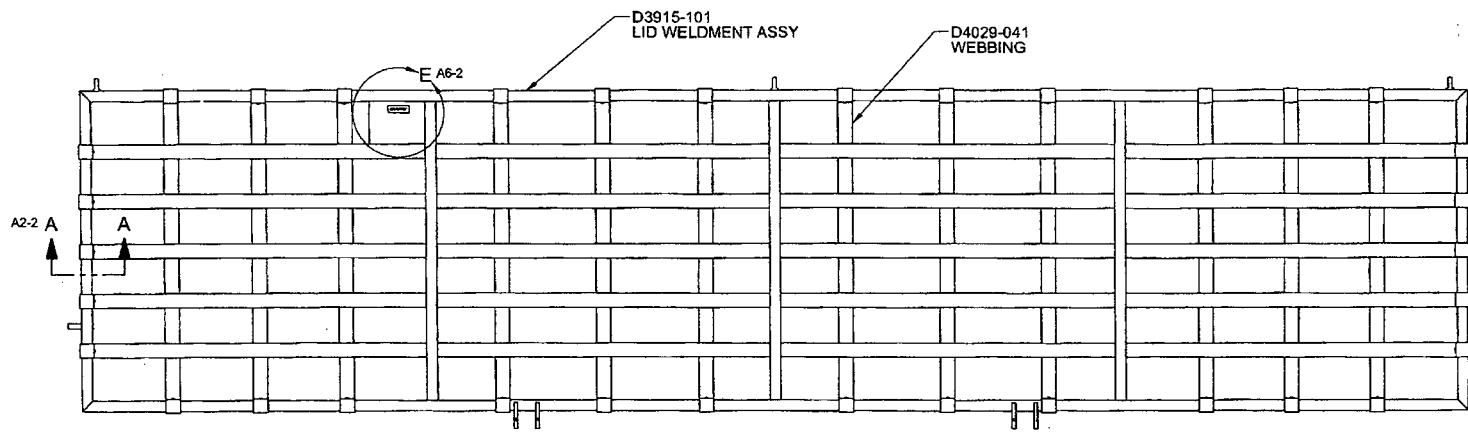
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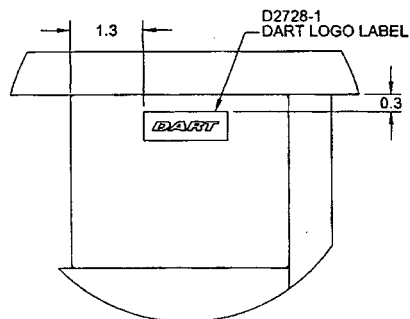
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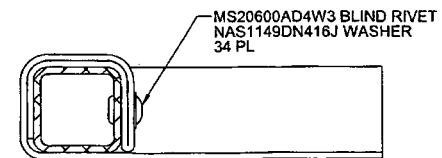
#67512



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D6-2



SECTION A-A C8-2

RELEASED
10.08.05

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SE	DRAWING NO. D3915	REV. C
MFG. APPR.	SE	SHEET 2 OF 4	
APPROVED	SE	TITLE	SCALE
DE APPR.	SE	LIGHT LID ASSY-LONG BASKET	
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR REPRODUCTION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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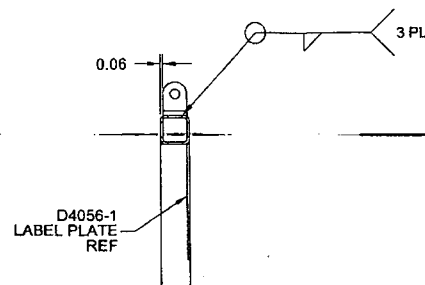
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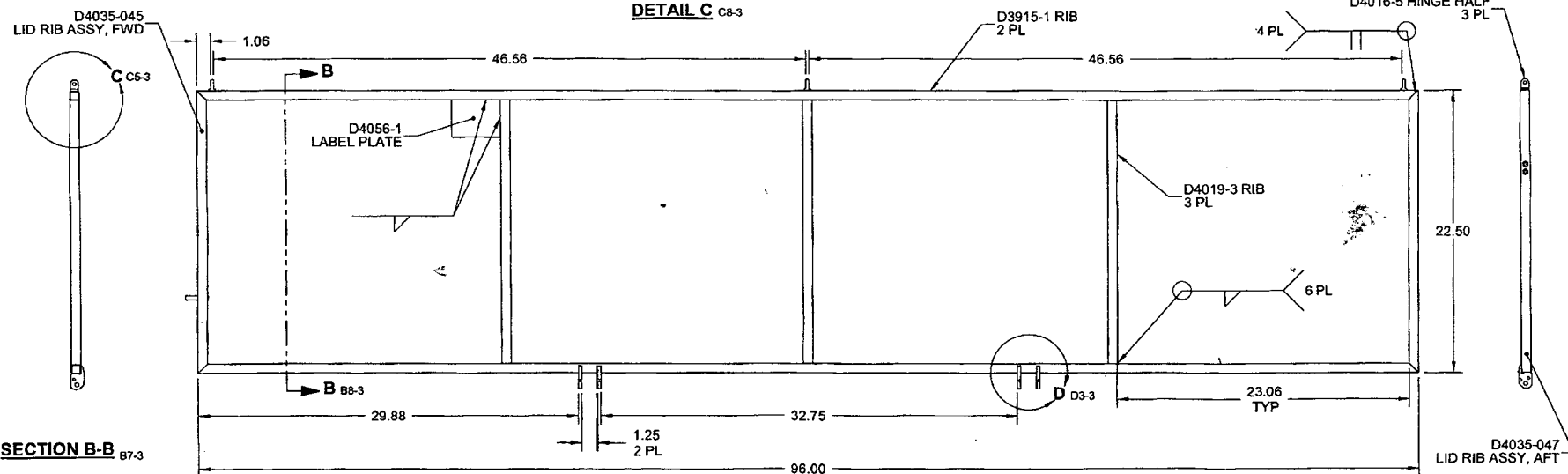
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ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



DETAIL D B3-3

DETAIL C C8-3



D3915-101 BASKET LID WELDMENT ASSY

RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	AGS	DART AEROSPACE LTD	
DRAWN	AGS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	AGS	D3915	SHEET 3 OF 4
APPROVED	AGS	TITLE	SCALE
DE APPR.	AGS	LIGHT LID ASSY-LONG BASKET	TNTS
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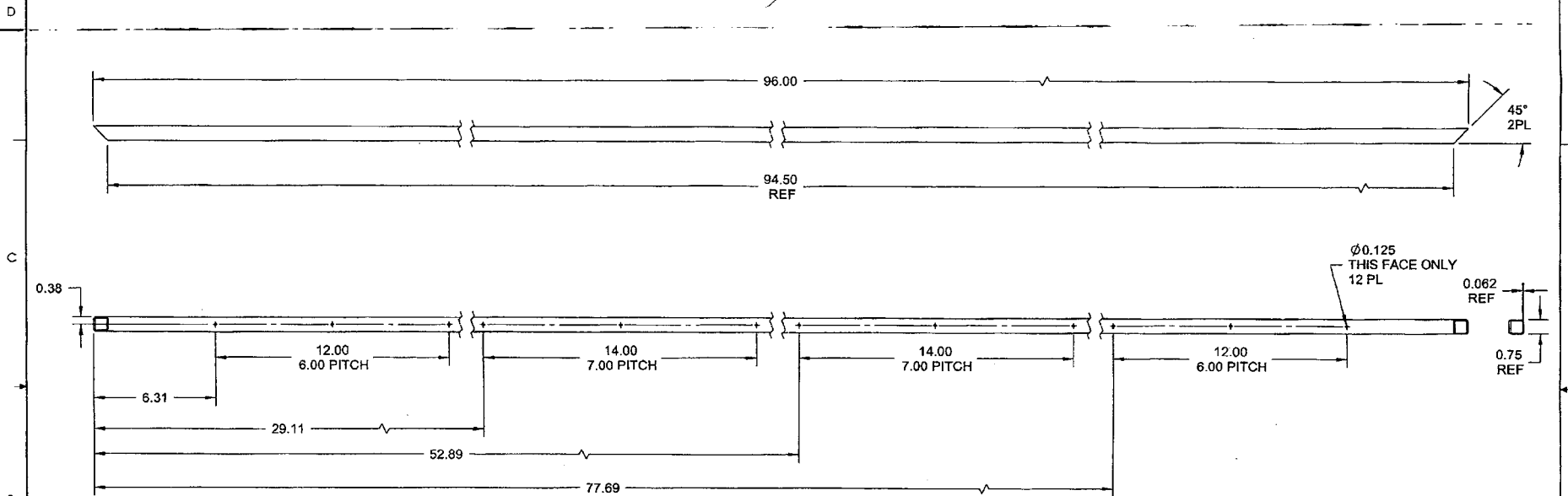
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3915-1 RIB

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.49 lbs

RELEASED
10-01-12 CP

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. C
CHECKED	SC	D3915	SHEET 4 OF 4
MFG. APPR.	MP	TITLE	SCALE
APPROVED	MP	LIGHT LID ASSY-LONG BASKET	NTS
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DATE	10.08.05		

8 7 6 5 4 3 2 1

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